

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014770**Date Inspected:** 13-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Xu Le Feng/ Mr. Liu Yang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW repair welding on; Spare strut Flange to web and the weld joint is identified as SD1-STSA4-5-119mtr.-1-48A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-FCM-Repair.

2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040724 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as SD1-STSA4-143 mtr.-1-13, 14. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2113.

3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040611 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-20-2A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-2-1B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040619/040704 perform SMAW welding on; West Shaft, Lift 5 Grillage plate and the weld joint is identified as WSD1-TL5-4 B/F-34A, 34B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-B-U3B. (Photo attached)

Bay no. 10

6.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044511 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as NSD1-SPSA5-6-4A. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

7.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as NSD1-SPSA5-19-2B. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as CD Corner Diagonal plate welding with Skin C & D of North shaft, Lift 4. The weld designations reviewed are as follows:

NSTL4- 3B/L – Jt. no – 20 –CD corner, North, Lift 4
NSTL4- 3C/L – Jt. no – 19 –CD corner, North, Lift 4
NSTL4- 3F/L – Jt. no – 77 –CD corner, North, Lift 4
NSTL4- 3G/L – Jt. no – 76 –CD corner, North, Lift 4
NSTL4- 3H/L – Jt. no – 4 –CD corner, North, Lift 4
NSTL4- 3I/L – Jt. no – 2 –CD corner, North, Lift 4
NSTL4- 3J/L – Jt. no – 70 –CD corner, North, Lift 4
NSTL4- 3K/L – Jt. no – 5 –CD corner, North, Lift 4

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Lift 4 to 5 Interior splice plate welding at Bay no. 10



West shaft -Lift 5 -Grillage plate welding at Bay no. 11



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer